

Date: Monday, 11/6/2006 2:39:03 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 29326		Part Number	: D25773		
Estimate Number	: 10298		Drawing Number	: D2577 REV E		
P.C. Number	: N/A		Project Number	: N/A		
This Issue	: 11/6/2006 S.O. No. : N/A		Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A Type : SMALL /MED FAB		Due Date	: 11/25/2006 Qty: 50 Um: Each		
Previous Run	: 28013					
Written By	: <u>ML</u> 06/11/07					
Checked & Approved By						
Comment	: Est: F 02.09.24 Re-format; Incorporated D2577-101/13KJ/ RF Est. C 06.07.21 waterjet EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
Comment: Qty.: 0.9240 sf(s)/Unit Total : 46.2000 sf(s) 47.124 1010/1025/A21/6aA SHEET 0.063 thick Batch: <u>m102684</u> <u>ML 06/11/27</u> <u>51</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut D2577-101 as per Dwg D2577 Dwg Rev: <u>E</u> Prog Rev: <u>E</u> <u>ML 06/11/28</u> <u>50</u>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ML 06/11/28</u> <u>50</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>ML 06/11/28</u> <u>51</u>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <u>ML 06/11/29</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA  Date: 26/12/18
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 29326

Part Number: D25773

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

2-Identify as D2577-3

SB 06/11/29

(51)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MO 06/11/29 (51)

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

PL06/12/05

(51)

Qty Description Batch

A/R 7560 Hardcoat Rod

m102756, m102154 MF. 06-12-05.

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

MO 06/12/06 (50)

10.0 POWDER COATING

POWDER COATING



M 197 20

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-k/a.m 06/12/14 (51)

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 12 18 (51)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP19

FC 06 12 18 (51)

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/18 (51)

Job Completion



06/12/18

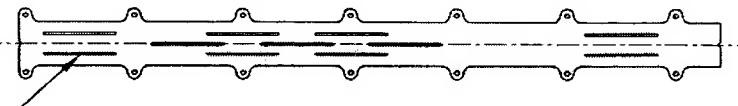
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NOTE: Date & initial all entries

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

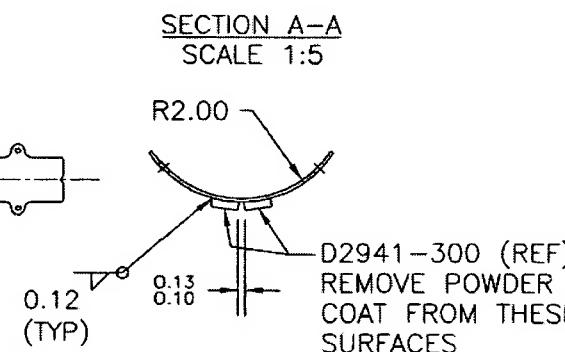
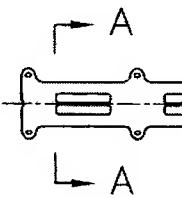


D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

Design
DRAFT

RELEASED
00-04-26 M

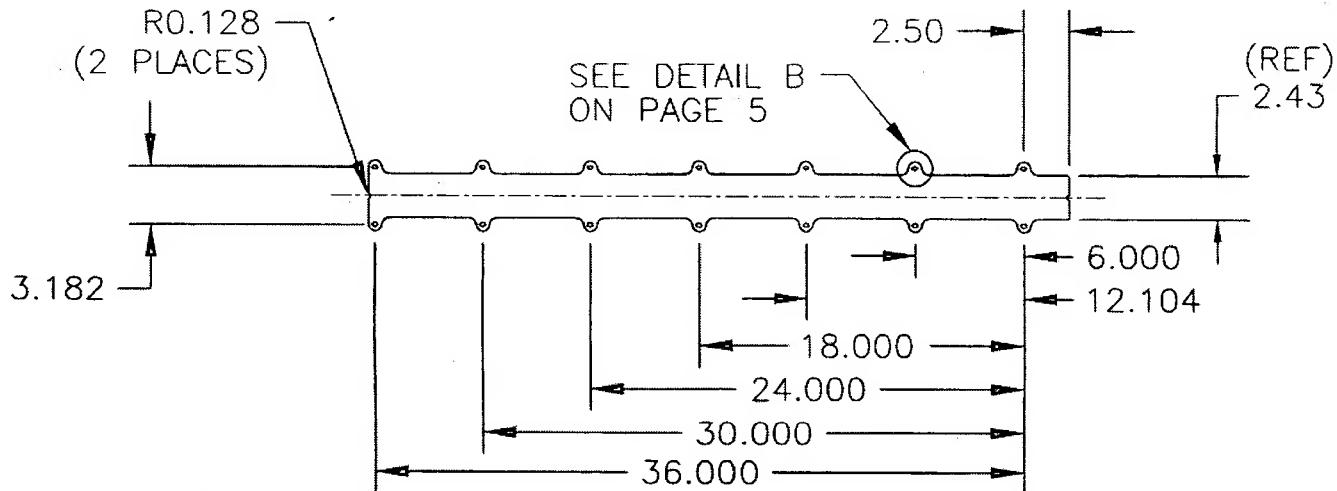
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CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 5
DATE			SCALE
00.09.22		WEARSHOE	1:10
A	96.09.16	NEW ISSUE	
B	96.12.04	ADD HARDCOAT WELDS	
C	97.05.30	CHANGE HOLES TO OBOUNDS	
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

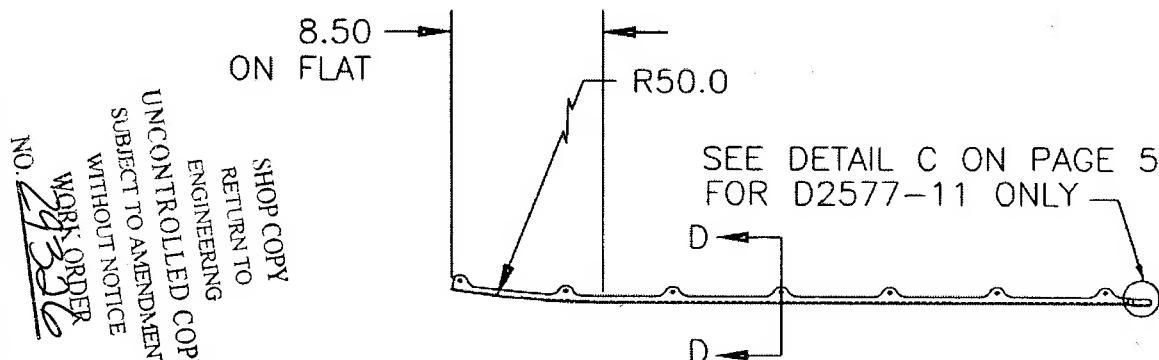


D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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06.09.26
45

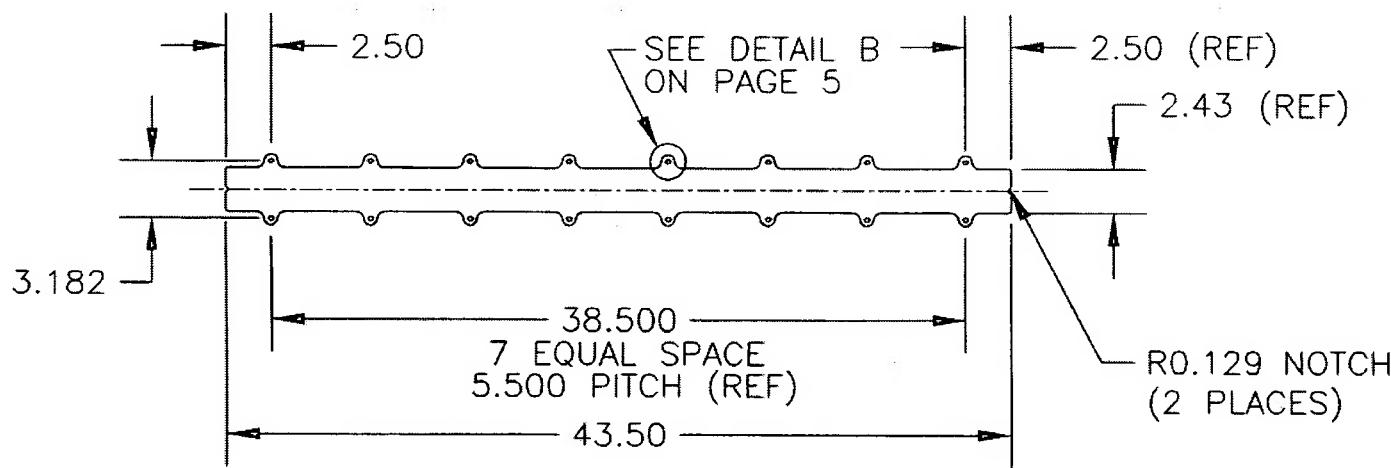
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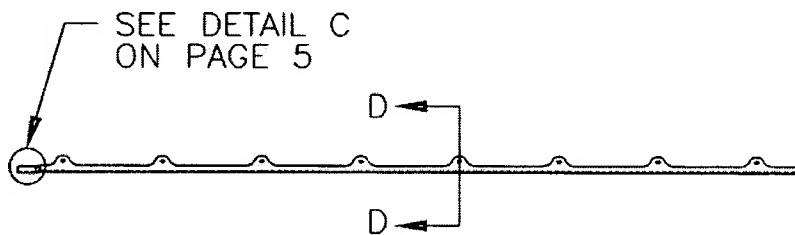
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

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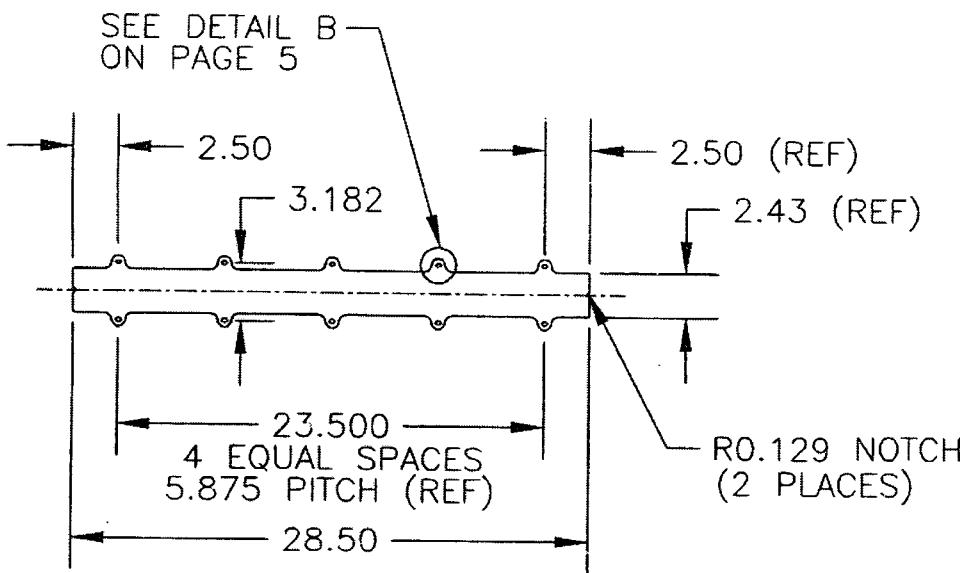
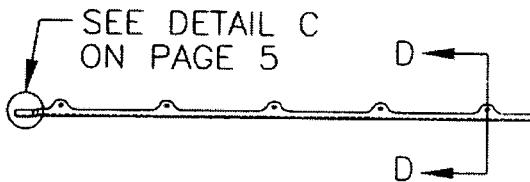
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		SCALE
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RELEASED
00 09 26 97D2577-7 FLAT PATTERND2577-7 LONGITUDINAL BENDD2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICKFINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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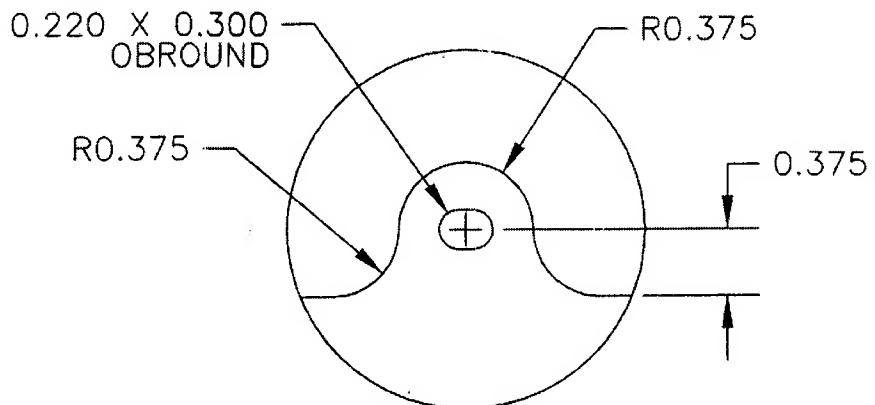
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DATE	00.09.22	TITLE	SCALE

SHEET 5 OF 5

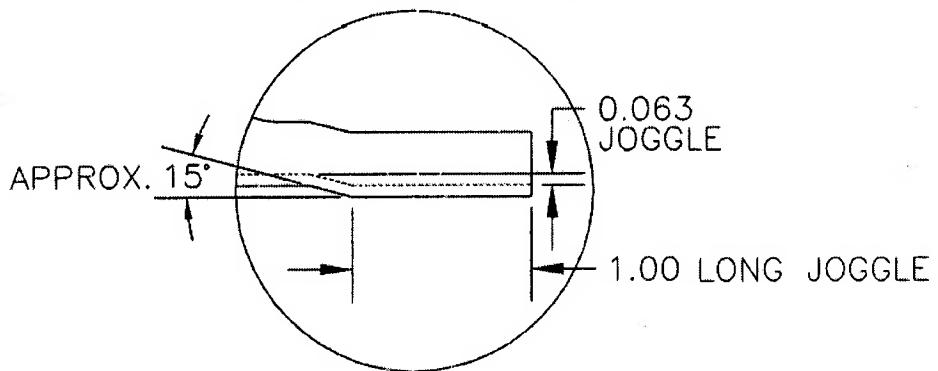
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DETAIL B (SCALE 1:1)

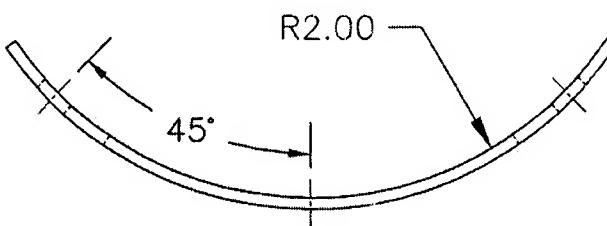
RELEASED
00.09.20 *MM*



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 29326

Description: We are plants

Part Number: D2571-3

Inspection Dwg: D2577 Rev: E

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:

ME. 4721

Audited by:

Prototype Approval:

Date: _____

08 11 28

Date: 06/11/28

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	